

Work Order ID 55190

January 11, 2010 11:36:10 AM



Page 1

Item ID: D3790-1

Accept



Setup Start



Revision ID:

Stop



Item Name: INDEXING BLOCK

Start Date: 1/11/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 1/18/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: mf Date: 10-01-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	----------------	--------------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3790

Rev B

100

0.00



Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT BLANK 5.90" LONG

mf 10-01-11

110

0.00



HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

MILL AS PER DWG AND FOLIO FA745

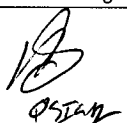
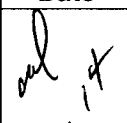
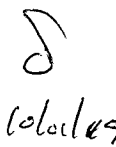
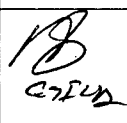
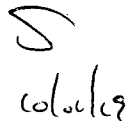
FOLIO REV: ABDWG REV: Bmf 10-01-11

DEBURR

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
10/10-14	120	2.100 DIMENSION OUT OF TOLERANCE, Operator error.		Qty 1 Scrap + doit replace	 10-10-14	 collected	 Chief Eng	 collected

NOTE: Date & initial all entries

Work Order ID 55190

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Page 2

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Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10-01-14

130



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

28 10/01/19

5 1

140



Packaging

Packaging

Identify as per dwg & Stock Location: *88*

0.00

Memo

0.00

10-1-19 5x 50

W/O:		WORK ORDER CHANGES					
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Page 3

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Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/19

ME 10-1-19

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

January 11, 2010 11:36:10 AM

Work Order ID: 55190



Parent Item: D3790-1



Parent Item Name: INDEXING BLOCK

Start Date: 1/11/2010

Required Date: 1/18/2010

Comments: IPP Rev:A New Issue 08-05-16 JLM Verified By:DD

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MDELRLNB2.000X3.00 0		Purchased	No				f	8.3900	3.1200			



Delrin Bar 2" x 3"

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

8.39

108068

0.39

112665

8

[Handwritten signature]

3.5

10.01.14

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 5579C
Description: Indexing Block		Part Number: D3790-1
Inspection Dwg: D3790	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.209	+0.005/-0.001	.213				
0.450 deep	+/-0.010	.450				
0.05 x 45°	+/-0.010 x 0.5°	.05 x 45°				
1.265	+/-0.010	1.265				
1.699	+/-0.010	1.699				
2.166	+/-0.010	2.166				
2.662	+/-0.010	2.662				
1.300	+/-0.010	1.300				
1.629	+/-0.010	1.629				
1.910	+/-0.010	1.910				
2.138	+/-0.010	2.138				
R0.25	+/-0.030	R0.25				
R3.62	+/-0.030	R3.62				
R4.249	+/-0.010	R4.249				
R5.50	+/-0.030	R5.50				
19°	0.5°	19°				
51°	0.5°	51°				
Ø0.525	+0.008/-0.001	.525				
Ø0.281	+0.006/-0.001	.281				
Ø0.625	+0.008/-0.001	.625				
4.97	+/-0.030	4.97				
3.100	+/-0.010	3.100				
1.038	+/-0.010	1.038				
0.500	+/-0.010	0.500				
2.100	+/-0.010	2.100				
12°	0.5°	12°				
1.42	+/-0.030	1.42				
1.13	+/-0.030	1.13				
0.38	+/-0.030	.38				
0.50	+/-0.030	.50				

Measured by: <i>[Signature]</i>	Audited by: <i>[Signature]</i>	Prototype Approval:	N/A
Date: 10.01.14	Date: 10/01/19	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.05.19	New Issue	KJ	<i>[Signature]</i>

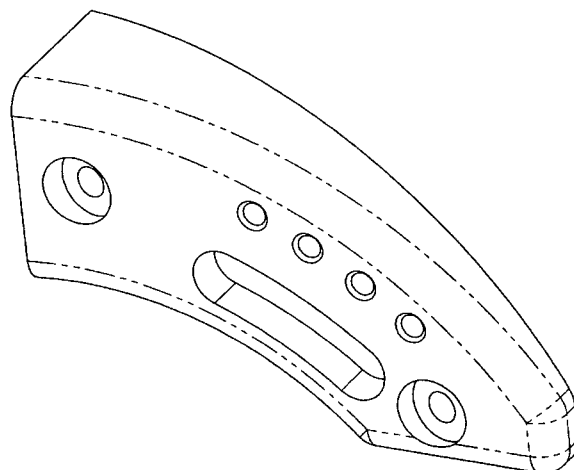
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NOTE: Date & initial all entries



#55190

RELEASED
08/02/05 MP

D3790-1 INDEXING BLOCK

NOTES:

- 1) MATERIAL: BLACK ACETRON GP ACETAL
(REF DART SPEC M-DELIN-B)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: SCRIBE WITH DART P/N "D3790-1" USING VIBRATING STYLUS
- 7) WEIGHT: 0.39 lbs

B	UPDATED NOTE 1 (ZN A8-1); Ø0.209 WAS Ø0.250 AND 4 PL WAS 5 PL (ZN D5-2); 19° WAS 25° (ZN C7-2). REASON: REDESIGNED TO ELIMINATE POSSIBLE INTERFERENCE BETWEEN D3705-041 AND D3676-1 AT INSTALLATION		MB	08.06.26
A	NEW ISSUE		MB	08.05.13
REV.	DESCRIPTION		BY	DATE
DESIGN	DRAWN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	MFG. APPR.		DRAWING NO.	REV. B
APPROVED	DE APPR.		D3790	SHEET 1 OF 2
DATE	08.06.26		TITLE	SCALE
			INDEXING BLOCK	NTS
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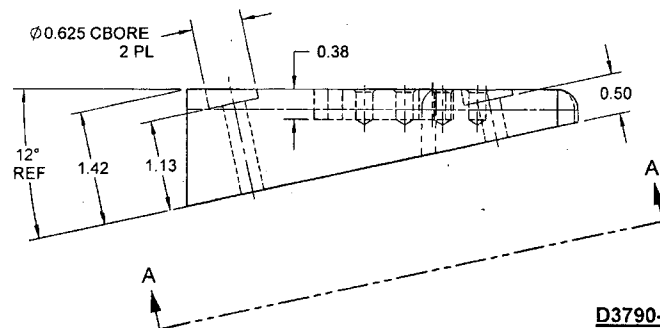
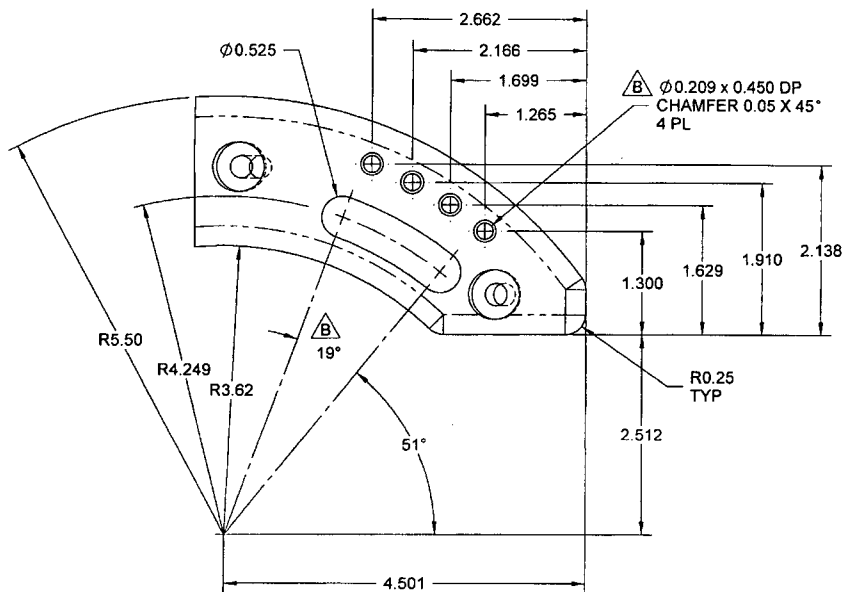
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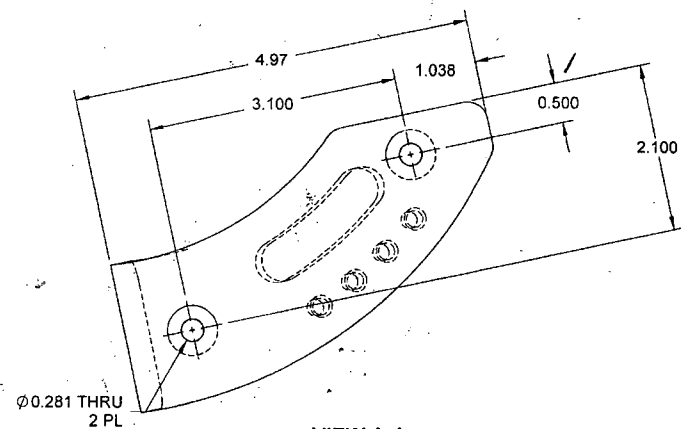
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NOTE: Date & initial all entries



D3790-1 INDEXING BLOCK



VIEW A-A

RELEASED
09/02/05

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3790	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		INDEXING BLOCK	NTS
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